

Date: Thursday, 12/06/2008 3:42:22 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG ASSEMBLY		
Job Number	: 39842			Part Number	: D27363		
Estimate Number	: 10012			Drawing Number	: D2736 REVA		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/06/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 30/06/2008 Qty: 50 Um: Each		
Previous Run	: 39223						
Written By	:						
Checked & Approved By	: <u>DRP 08-06-12</u>						
Comment	: Est Rev:D Removed from 9 digit 05-10-25 JLM						

Additional Product

}

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2591	Lug, GHW Adapter	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D2591	Lug	<u>B39240 → 21X</u> 08-06-18 SP
2.0	D27353	Lug Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D2735-3	Lug Bracket	<u>B38033 → 21X</u> 08-06-18 SP
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484	
		Steel Rod Batch: <u>M19317</u>	<u>08-06-18</u> SP
4.0	QC9	VISUAL WELDING INSPECTION	
		Comment: VISUAL WELDING INSPECTION	
5.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/06/2008 3:42:22 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



11107925

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 1:30 PM

OVEN TEMPERATURE: 400°

FINISH TIME: 2:00 PM

9/1

08-06-19

(X2)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F-2 08/06/20

(2)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



(21)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 471A

8/6/20

50

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/20

Comment: FINAL INSPECTION/W/O RELEASE

mf 08-06-20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

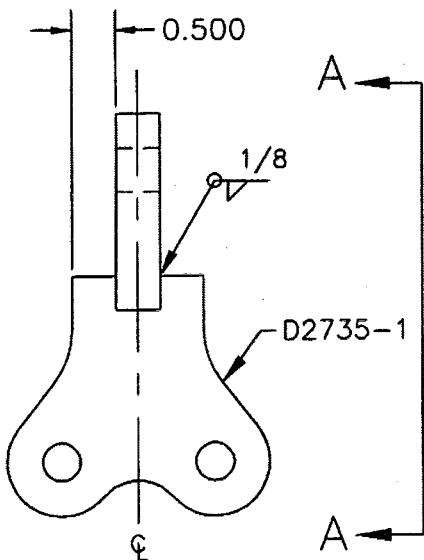
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

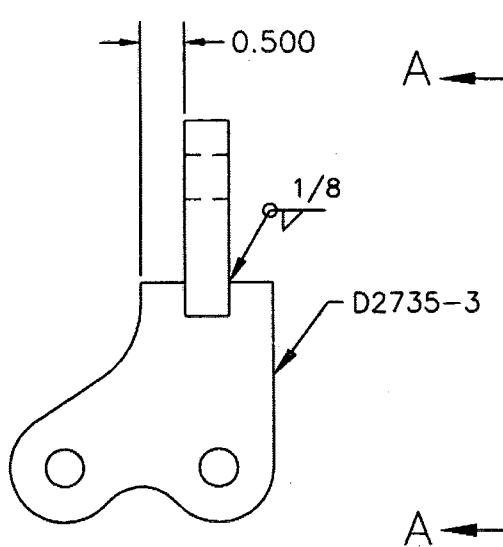
NOTE: Date & initial all entries



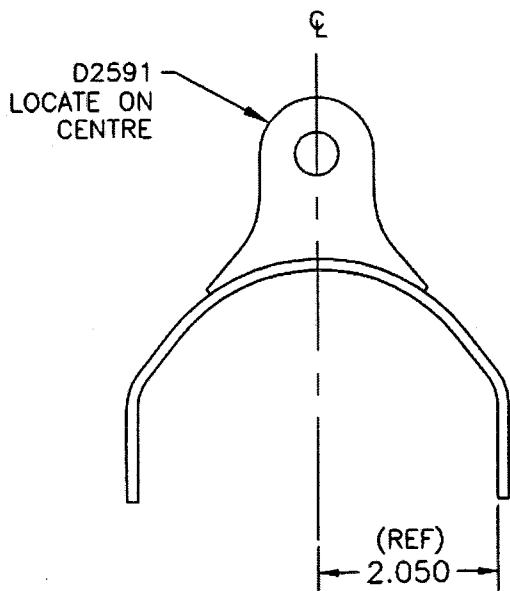
DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>RE</i>	APPROVED <i>J</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
	A	97.12.18	NEW ISSUE



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

RELEASED
97/12/24 DS

ECN 057

SHOP COPY
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ENGINEERING

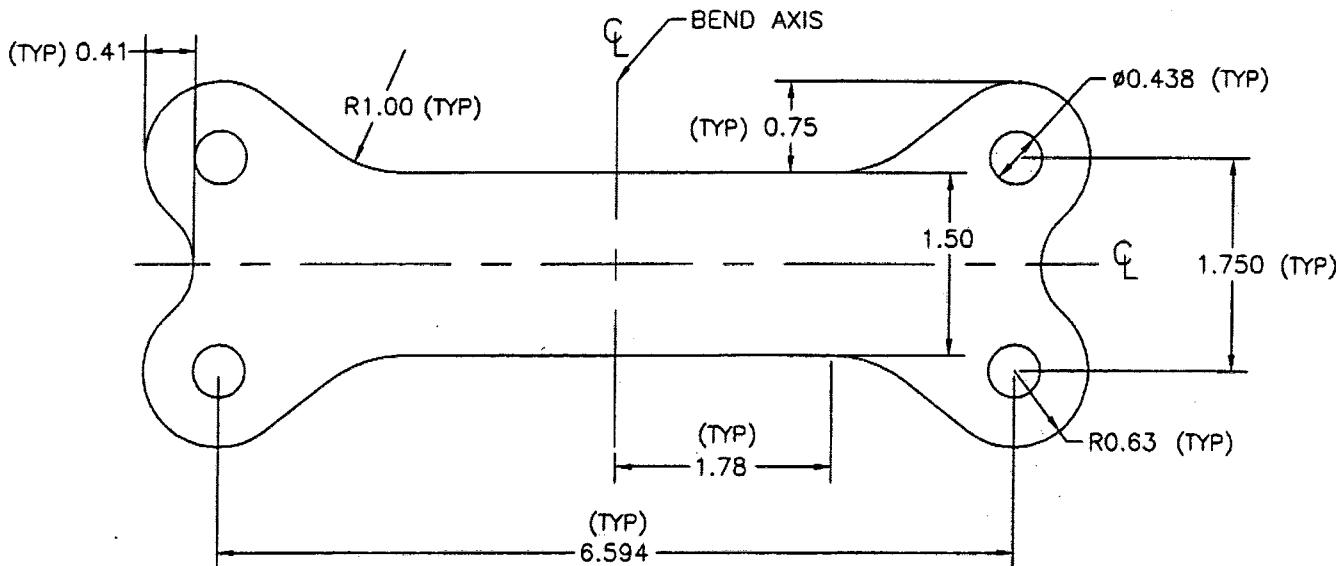
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

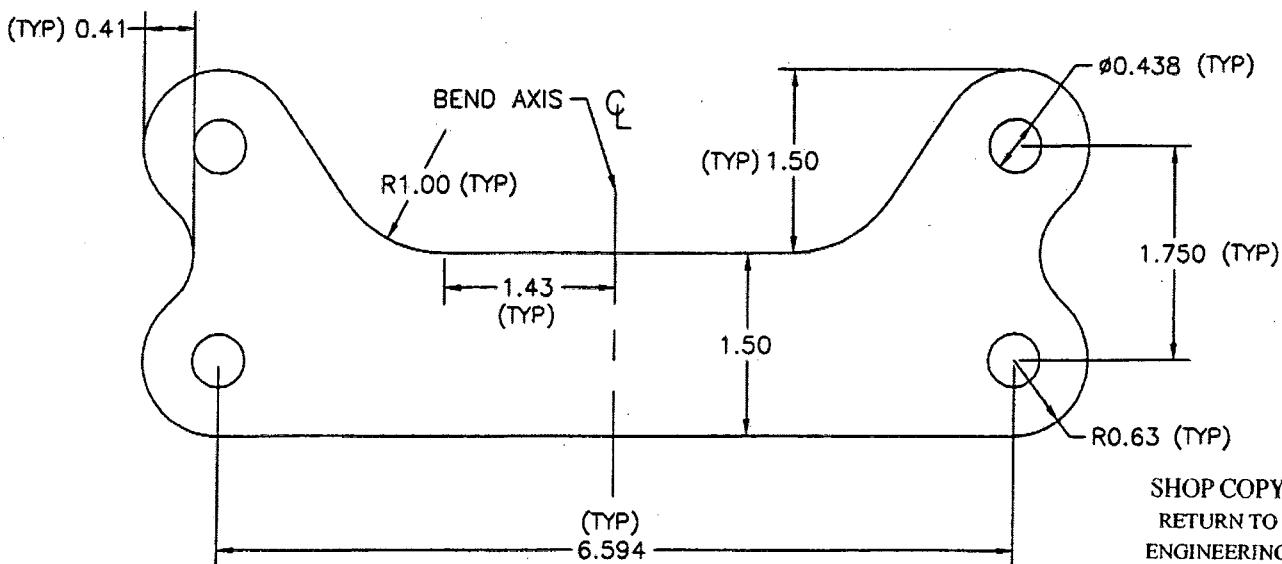
NO. 3892

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>CP</i>	<i>KE</i>	D2735	SHEET 1 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS

D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)

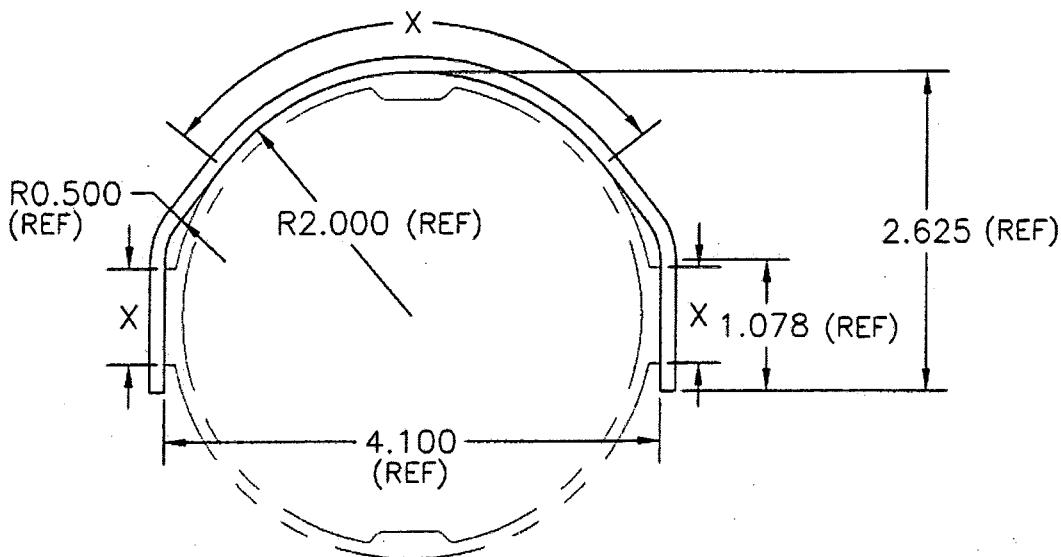


D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)

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WORK ORDER
NO. 39848

DART

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
18.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *37812*